

Work Order ID 53878



Page 1

November 23, 2009 10:54:54 AM

Item ID: D4010-041

Accept



Setup Start



Revision ID:

Item Name: Bearpaw Assembly

Stop



Start Date: 11/30/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 12/2/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *Mf*

Date: 09-11-23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4010-041	C

100



HandThermo

Hand Finishing Thermoforming

Memo

0.00

110



HandThermo

Hand Finishing Thermoforming

Memo

0.00

- 1- Use wearplate jig DT9542 to transfer drill holes in bearpaw as per dwg and use 0.375" unibite to open holes to finish size.
- 2- Use wearbar to transfer drill hole and open to finish size as per dwg
- 3- Deburr
- 4- Assemble as per Dwg D4010

*BB 09/12/15**BB 09/12/15**X12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

3309/12/15

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 808015

140



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

PPO

53225

0.00

(12) - f

Loyd 12

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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC21- Final Inspection - Work Order Release

0.00

QC
Quality Control

Memo

0.00

10/01/06 JJ
MK
LOP
10-01-05

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Picklist Print

Page 1

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Work Order ID: 53878



Parent Item: D4010-041



Parent Item Name: Bearpaw Assembly

Start Date: 11/30/2009

Required Date: 12/2/2009

Comments: IPP RevB: 09/11/03 Drawing changed to accomidate OEM and Dart Skidtube.
DL. Verified by:DD
Redesign 09/11012 DL VERIFIED BY:DD

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/ Purchased	Bin	Primary No	Last	Route	Unit of Each	Qty on 1,104.000	Remaining 60.0000	Qty	Date	Status
AN3C5A						100						



Bolt

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Main Warehouse

ST	1104	
111424	8	
111707	69	
112314	1	SD
112641	426	
113121	300	SD
113149	300	

BB 09/12/15

D3456-1RevA



Manufactured No

100 Each 155.0000 36.0000



Washer

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

OFFSHORE

FG	7	
25701	7	

BB 09/12/15

Main Warehouse

ST	148	
51653	148	48

D4010-1



Manufactured No

100 Each 0.0000 12.0000



Bearpaw

53879 X12 BB 09/12/15

W/O:		WORK ORDER CHANGES					
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DL. Verified by:DD
Redesign 09/11012 DL VERIFIED BY:DD

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 0.0000	Remaining 12.0000	Qty	Date	Status
D4013-041										53880	X12	BB 09/12/15

Wearplate Assembly

D4015-041		Manufactured	No			100	Each	22.0000	60.0000		
-----------	--	--------------	----	--	--	-----	------	---------	---------	--	--

Wearbar Weldment

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

HONG KONG

MS21043-3	Purchased	No	53252 53818	100	Each	4,825.000	60.0000				BB 09/12/15
-----------	-----------	----	----------------	-----	------	-----------	---------	--	--	--	-------------

Nut

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

OFFSHORE

FG	80	
----	----	--

103691

80

Main Warehouse

ST	4745	
----	------	--

111819

4745

112243	78	
--------	----	--

112314

78

112314	39	
--------	----	--

112314

39

112314	4628	
--------	------	--

112314

4628

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DL. Verified by:DD
Redesign 09/11012 DL VERIFIED BY:DD
IPP Rev. C Dwg.

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route	Unit of Each	Qty on 1,341.000	Remaining 36.0000	Qty	Date	Status
MS21043-4						100						



Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
OFFSHORE			
FG	40		
104603	40		
Main Warehouse			
ST	1301		
112243	2		
112314	499		
112492	300		
113064	500	48	

Bo7/2/15

W/O:		WORK ORDER CHANGES					
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8 7 6 5 4 3 2 1

D

D

C

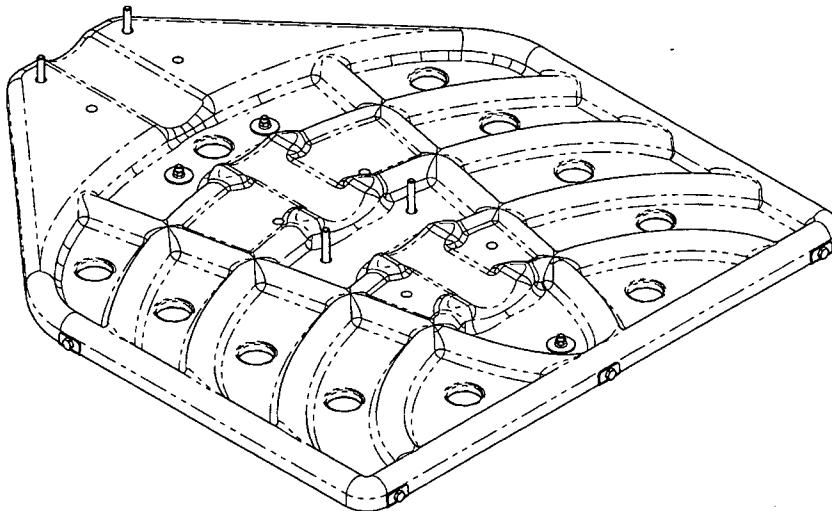
C

B

B

A

A

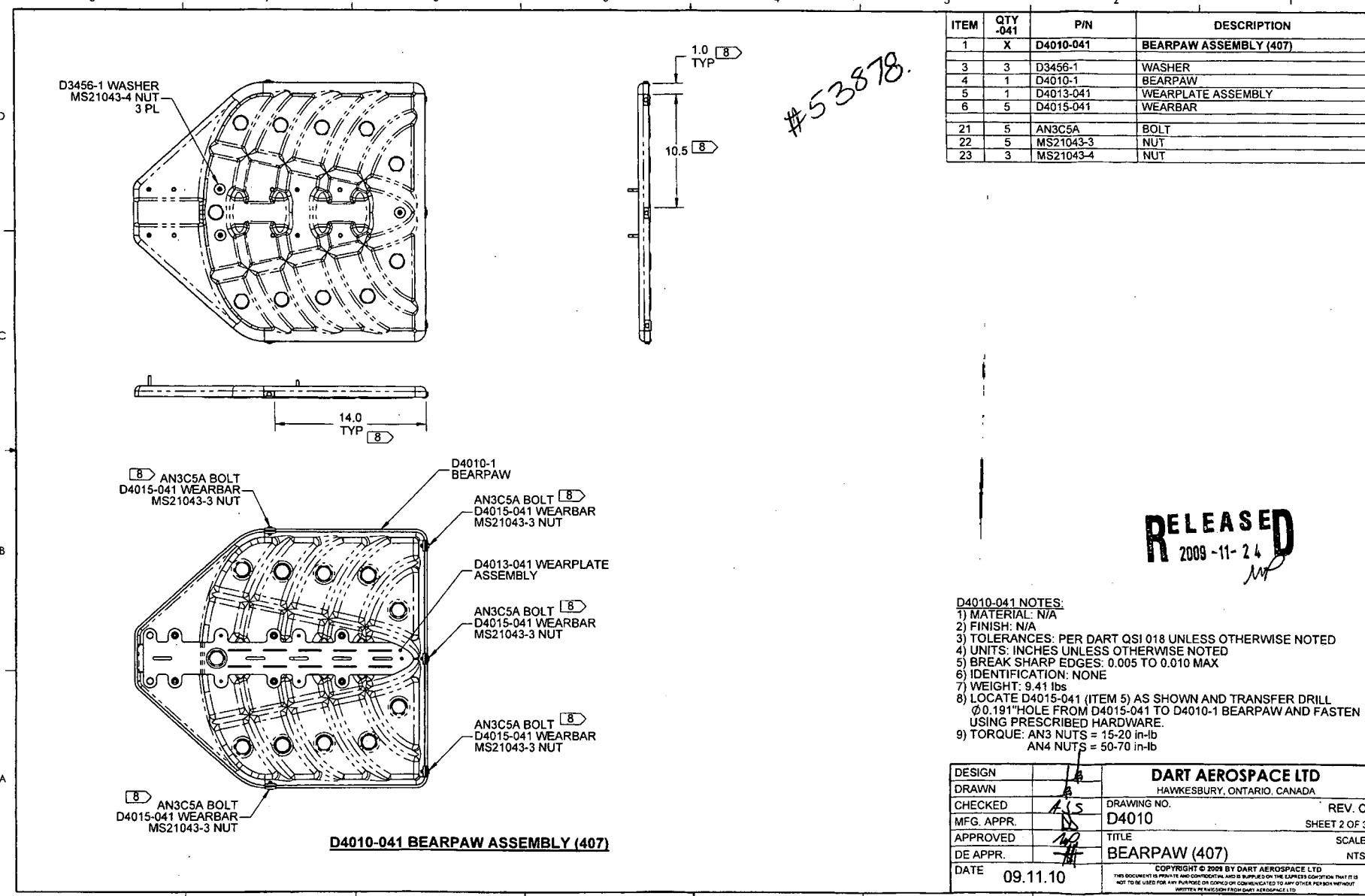


#53818

D4010-041 BEARPAW ASSEMBLY (407)

RELEASED
2009-11-26
M

C	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED; ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION		BY DATE
DESIGN	<i>14</i>		DART AEROSPACE LTD
DRAWN	<i>14</i>		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>TS</i>		DRAWING NO.
MFG. APPR.	<i>DN</i>		D4010 REV. C
APPROVED	<i>14</i>		SHEET 1 OF 3
DE APPR.	<i>14</i>		TITLE
DATE	09.11.10		SCALE
			BEARPAW (407) NTS
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#53878

